

Date: Tuesday, 10/06/2008 3:14:32 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 39805	
Estimate Number : 10175	
P.O. Number :	Part Number : D2570
This Issue : 10/06/2008 S.O. No. :	Drawing Number : D2570 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 39369	Material :
Written By :	Due Date : 23/06/2008 Qty: 500 Um: Each
Checked & Approved By : <u>JUD 08.6.10</u>	
Comment : Est E 02.08.29 Re-format; Removed finishing; Material change K J est F 07.07.06 rev B dwg EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M303R0750

303 Round Bar .75"



Comment: Qty.: 0.0810 f(s)/Unit Total : 40.4775 f(s)
 Material: Ø0.750 AISI 303 SS Rod (M303R0.750)
 Batch M10820 mmf 08/06/13

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 Machine as per folio FA198
 Deburr mmf 08/06/13

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE
mmf 08/06/13

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK
J.L 08/06/18

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 37 8/16/18 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 3:14:33 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 39805

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-18

#45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	39805
Description: Bushing		Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.801	✓			
0.060	+/-0.005	.062	✓			
R0.010	+0.010/-0.000	R0.010	✓			
Ø0.425	+0.000/-0.002	Ø.424	✓			
Ø0.257	+0.005/-0.000	Ø.257	✓			
Ø0.750	+/-0.010	Ø.749	✓			
0.030 x 20°	+/-0.010	.030 x 20°	✓			

Measured by: mmf/gml	Audited by: J.L	Prototype Approval:	N/A
Date: 08/06/13	Date: 08/06/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	BE

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

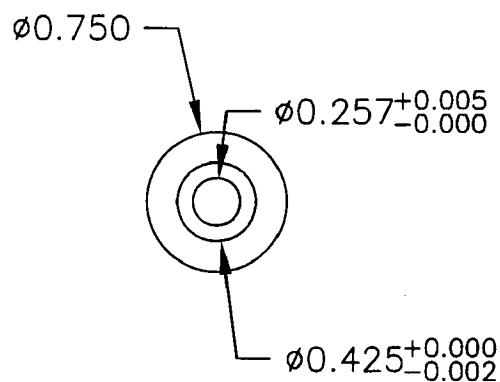
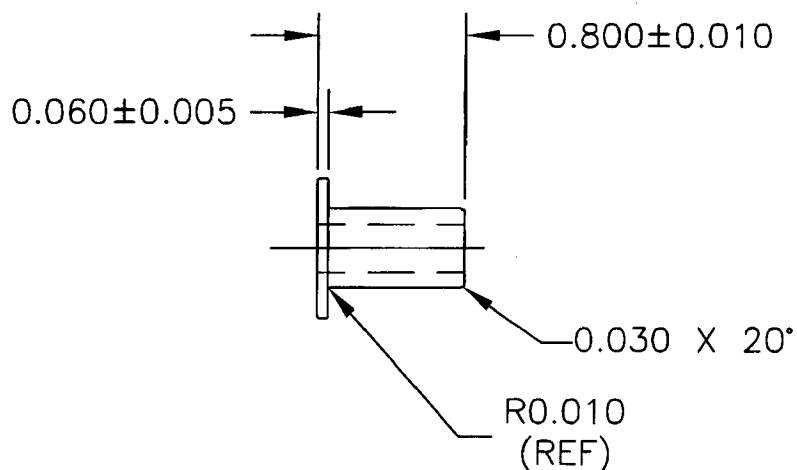
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NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
07.06.28 *#***D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39805

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Dart Aerospace Ltd

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